











Work Order ID 72473

Tuesday, July 26, 2011 9:09:13 AM

Page 1

Item ID:	D4131-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Doubler Assembly				Stop	
Start Date:	7/26/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	7/29/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4131	A U/R <i>see attached email</i>								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4131-7 as per Dwg								
<i>6661-063</i>	Dwg Rev: <i>U/R</i>								
	Prog Rev: <i>U/R</i>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							
Quality Control									

B11-8-3

(12)

B11-8-3

Suloslo3

(712)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4131-043

Accept



Setup Start



Revision ID:

Item Name: Doubler Assembly

Stop



Start Date: 7/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

COUNTER SINK AS PER DWG

Deburr if necessary.

[Signature] 7/26/08/07 (12)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

[Signature] 7/26/08/10

(12)

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

12 *[Signature]* 7/26/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D4131-043

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Setup Start

Revision ID:

Stop

Item Name: Doubler Assembly

Start Date: 7/26/2011 Start Qty: 10.00

Required Date: 7/29/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

161

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12x Ø M-11/08/11

165

Memo
ASSEMBLE NUT PLATES AS PER DWG

0.00



Small Fab

Small Fab

0.00

LPS 11/08/15 (12x)

166

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/15

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4131-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 7/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Identify as per dwg & Stock Location: 132

0.00

Memo

0.00

JD11/8/15(12)

Packaging

190



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/8/15MF
11-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 26, 2011 9:09:18 AM

Page 1

Work Order ID: 72473

Parent Item: D4131-043

Parent Item Name: Doubler Assembly







Start Date: 7/26/2011

Required Date: 7/29/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	211.4456	0.1807	1.902105	10		
											B11-8-3		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		211.4455684							
				116308		26.9755684							
				117285		184.47							
MS20426AD3-3  Rivet		Purchased	No			165	Each	1,963.000	8	80			
													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		1963							
				19099		1963							
MS21069L3  ANCHOR NUT		Purchased	No			165	Each	93.0000	4	40			
													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST302		93							
				103447		1							
				115708		4							
				118003		88							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

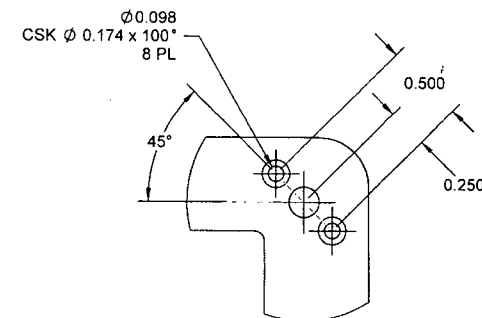
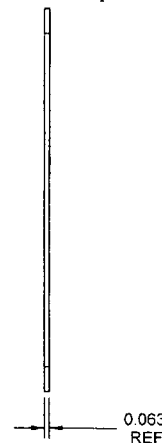
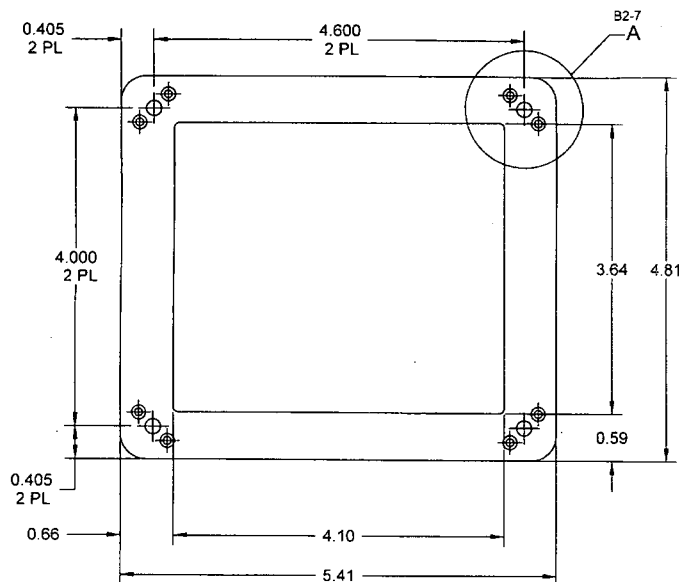
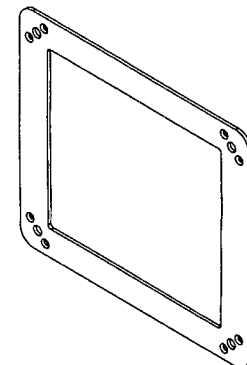
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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WORK OF OR
NO. 22473

11-07-24



UNDER REVIEW
11/07/20/24

DETAIL A D5-7
TYPICAL

D4131-7 PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS4027
OR ASTM B209
PER DART SPEC. M6061T6S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

RELEASED
2010-09-23

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>MS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MS</i>	D4131	SHEET 8 OF 8
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	MANIFOLD ASSEMBLY	NTS
DATE	10.09.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

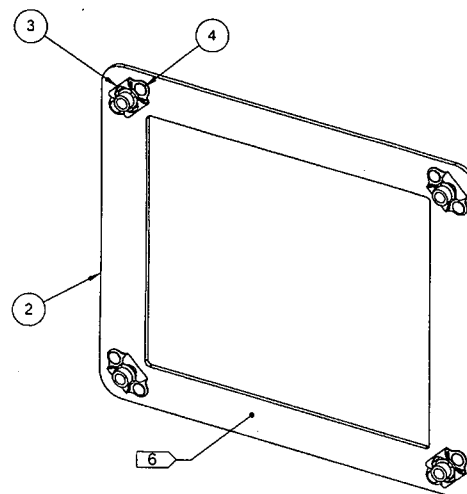
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	4	MS21069L3	NUT PLATE
4	8	MS20426AD3-3	RIVET



D4131-043 DOUBLER ASSEMBLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12473

11/07/26

UNDER REVIEW
11/07/26

RELEASED
2010-09-23
WNP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4131	REV. A
MFG. APPR.	<i>RF</i>	TITLE MANIFOLD ASSEMBLY	SHEET 2 OF 8
APPROVED	<i>RF</i>	SCALE	NTS
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DATE	10.09.16		

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: David Shepherd <dshepherd@dartaero.com>
Sent: July 22, 2011 1:00 PM
To: 'Linda Lacelle'; 'Roberto Fuentes'
Cc: Mike Petsche; 'Kim Johnston'
Subject: RE: Under Review - D4092, D4093, D4153, D4074 and D4131

Linda,

as discussed:

- a) D4092/D4093 should not be manufactured as is
- b) There are changes coming on D4153 and D4131, but it is acceptable to manufacture and release parts that are made per per D4153 Rev A and D4131 Rev A
- c) All D4074-X parts must be manufactured per D4074 Rev B ... There is no change to D4074-1/-5 but changes are required to D4074-3/-7. D4074 Rev B should arrive in Hawkesbury today.

Hope this clarifies the situation ... Sorry for any confusion.

David

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: July-22-11 7:16 AM
To: 'Roberto Fuentes'
Cc: dshepherd@dartaero.com
Subject: RE: Under Review - D4092, D4093, D4153, D4074 and D4131

have kits to ship next week, and more the week after, when is 4074, 4153 and 4131 all going to be released??

From: Roberto Fuentes [mailto:rfuentes@dartaero.com]
Sent: July 20, 2011 11:45 AM
To: Linda Lacelle
Cc: 'Stocker, Alan'; 'Beckett, Bill'; 'Golden, Brigitte'; 'Lavoie, Chantal'; 'Provencal, Chris'; 'Campbell, Daniel'; 'Duval, David'; 'Shepherd, David'; 'Charbonneau, Eric'; 'Downing, Eric'; 'Siemens, Harvey'; 'Jean-Francois Sauve'; 'Menard, Jean-Luc'; 'Johnston, Kim'; 'Fauteux, Melanie'; 'Petsche, Mike'; 'Willems, Sian'; 'Bedford, Sue'; 'Sheldon, Susanne'; 'Kerr, Cathy'; Marc Bellavance
Subject: Under Review - D4092, D4093, D4153, D4074 and D4131

Hi everyone,

D4092, D4093, D4453, D4074 and D4131 drawings are now under review per attached form.

Thanks,
Roberto

